Work Order ID <i>(</i> Tuesday, September 07, 20		1							e Vise	w Ye			Page 1
Item ID: D3502-1 Revision ID:				A	ccept					s	etup Star		
Item Name: Support							••		٠.		Stop		
Start Date: 9/7/2010 Required Date: 9/13/2010 Reference:	Start Qty: Req'd Qty			1 1 1 1 1 1 1 1 1 1		•	st Item I stomer:	D:			•		
Approvals: Process QC:	Plan:	11	Date: <u>//</u> /	208	Tooling: SPC (Y/N):			ate:		R	un Star Stop		
Sequence ID/ Work Center ID	Operation Description	n .	4		Set Up/ Run Hours		ool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr F	Revision Nbr			* ***							:		
D3502 F	Rev B			ř.		1	٠.	-	-				
100 		1emo Lut blank 3.47	75 " long□1 E	BLANK MAK	0.00 0.00 ES 2 PARTS	art	10/04	1/25		12	Ø	• • •	
110 HAAS 1 HAAS CNC vertical machine #1	1	VERTICAL M 1emo, - - Mill as per Fer dwg D3502	Folio FA649 F	` ;	0.00 0.00 Dwg D3502 Rev	and		/ 30	€	_/2_			

120

QC2- Inspect parts off machine FAI/FAIB

0.00

culidog/30

Memo

Quality Control

0.00

										•
W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•										
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es No	o DQ	4 :	_ Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C	Clos	ed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	CTED	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Secti		Chief Eng	QC Inspector
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Work Order ID 61843

Tuesday, September 07, 2010 3:19:57 PM



Page 2

Item ID:

D3502-1

Accept



Setup Start

Stop

Start



Revision ID:

Item Name:

Support

Start Date: 9/7/2010 **Required Date: 9/13/2010**

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Date:_____

Tooling:

0.00

SPC (Y/N):

Date:

Date:

Stop

Sequence ID/

Work Center ID

130

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00 Bf 10-10-6

Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Run

Reject Number

Insp. Stamp

Quality Control

140

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Mark hole position using DT9430 □ Drill as per Dwg D3502.

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

W/O:	-		WC	RK ORDER CHANG	ES		····			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #: esolution:								
NCR:				ER NON-CONFORM						
DATE	OTED	Description of NC			tion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		& Section C		Chief Eng	QC Inspector
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Work Order ID 61843

Tuesday, September 07, 2010 3:19:57 PM



Page 3

Item ID:

D3502-1

Revision ID: Item Name:

Support

Start Date:

9/7/2010

QC:

Start Qty: 12.00

Required Date: 9/13/2010



Accept



Cust Item ID:

Customer:

Tool ID

Setup Start

Stop



Req'd Qty: 12.00

Reference:

Approvals:

Process Plan: _____

Date:

Date:_____

Tooling: SPC (Y/N):

Set Up/

Run Hours 10-10-7.

Date:

Tool # Plan

Code

Date:

Run Start

Reject

Qty

Accept

Qty

Stop



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

170

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

180

Packaging

0.00

0.00

(1/1/12 D

Packaging

Memo

Identify as per dwg & Stock Location: 063

W/O:			WO	RK ORDER CHANG	ES					,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·		,						
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Ye	es No	DQ/	A :	_ Date: _	
	R	esolution:	Disposition	l:	_ QA: N/C	Clos	ed:		Date: _	
NCR:		\	WORK ORDE	ER NON-CONFORMA	ANCE (N	CR)			*	
DATE	OTED	Description of NC	Description of NC Co				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Secti		Chief Eng	QC Inspector
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Work Order ID 61843

Tuesday, September 07, 2010 3:19:57 PM



Page 4

Item ID:

D3502-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Support

9/7/2010

Start Oty: 12.00

Required Date: 9/13/2010 Reg'd Oty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date: Date: Start

Stop

Stop



QC:

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Code

Tool # Plan

Reject Accept Qty Qty

Run

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

190

Quality Control

Memo

OC21- Final Inspection - Work Order Release

0.00

0.00

										1
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR	: Yes N	lo DQ	A:	Date:	
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NCR:			WORK ORE	DER NON-CONFORMA	ANCE	(NCR)		•		
DATE	STEP	Description of NC			ion B	<u> </u>	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

Tuesday, September 07, 2010 3:20:08 PM

Work Order ID: 61843

Parent Item: D3502-1

Parent Item Name: Support



Start Date: 9/7/2010

Required Date: 9/13/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-07-06 JLM IPP Rev:B Add tooling hole 07-03-28

Esr

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	73.4494	0.289	3.650526	·- ·	·	

6061-T6 Bar 1.00 x 4.00

Location Loc Qty Loc Code MAT03 73.4494 107221 58.58 **114352** 14.8694

3.6505 onl 10/09/25

W/O:			V	VORK ORDER CHANG	GES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	· · · · · · · · · · · · · · · · · · ·
	R	esolution:	Disposit	ion:	QA: N/C CI	osed:	Date: _	
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NCF	R)	٤	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sign 8 Date	Verification Section C		Approval QC Inspector
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DART AEROSPACE LTD	Work Order:	61843
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

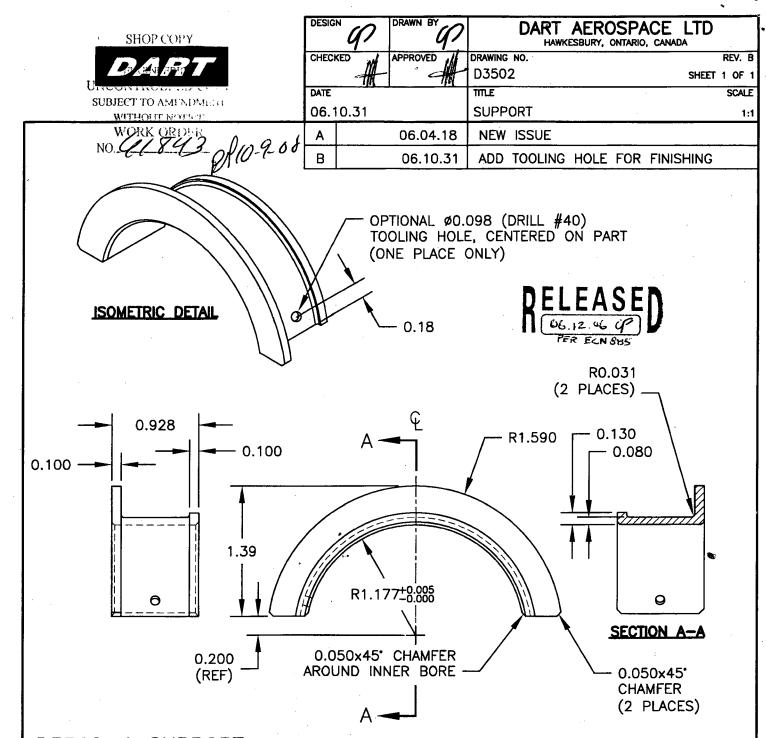
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.590	+/-0.010	R1.590			H-asso	3/10/
R1.177	+0.005/-0.000	RIAZ			Wern	ML-7
0.130	+/-0.010	.127			Vern	ML-7
0.080	+/-0.010	・ヴァフ			١(91
0.928	+/-0.010	430	/		14	11
0.100	+/-0.010	096	1		74	1/
0.100	+/-0.010	. 103	_		٢,	11
1.39	+/-0.030	1.345			Heist-an	y 31006
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Measured by:	and	Audited by:	B.A	Prototype Approval:	N/A
Date:	10/09/30	Date:	10/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM 1-A	1
В	07.03.29	Dwg Rev. updated	KJ/JLM A	
			111	//

W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	_ Fault Cate	gory:	NCR: Yes	No DQA :	Date: _	· · · · · · · · · · · · · · · · · · ·	
	Re	esolution:	lution: Disposition:			QA: N/C Closed:			
NCR:		V	ORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	1 Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C.	Chief Eng	QC Inspector	
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<u>D3502-1 SUPPORT</u>

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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	1.4.34									i		
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Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	_ Date: _			
				Disposition: Q/								
NCR:		***		DER NON-CONFO								
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip		Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector		
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